

Date: Wednesday, 3/21/2007 3:40:58 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 31407D		
Estimate Number	: 10356		
P.O. Number	:	Part Number	: D2279
This Issue	: 3/21/2007 S.O. No. :	Drawing Number	: D2279 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 30813D	Material	:
Written By	:	Due Date	: 4/10/2007 Qty: 20 Um: Each
Checked & Approved By	: <u>7.03.22</u>		
Comment	: Est Rev: A New Issue 05-11-07 JLM Est Rev: B Now on Waterjet 06-07-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1544 sf(s)/Unit Total : 3.0870 sf(s)  
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick  
 (M2024T3S.040)  
 Identify as D2279  
 Batch: M104025

- M1 07 06 16 (20)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D 2279  
 Dwg Rev: 0  
 Prog Rev: 0

M1 07 06 16

(20)

2-Debur if necessary

MF 07-06-25

(20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M1 07 06 16

(20)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07 06 18 (20)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Form As per Dwg D2279

SA 08/03/19 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: D Date: 08/03/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP SPACER

Job Number: 31407D

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/19 42

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

42

08-03-20

420

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1

08/03/20

20X

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: GA

SB

08/03/20

20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/20

Job Completion



U 08-03-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

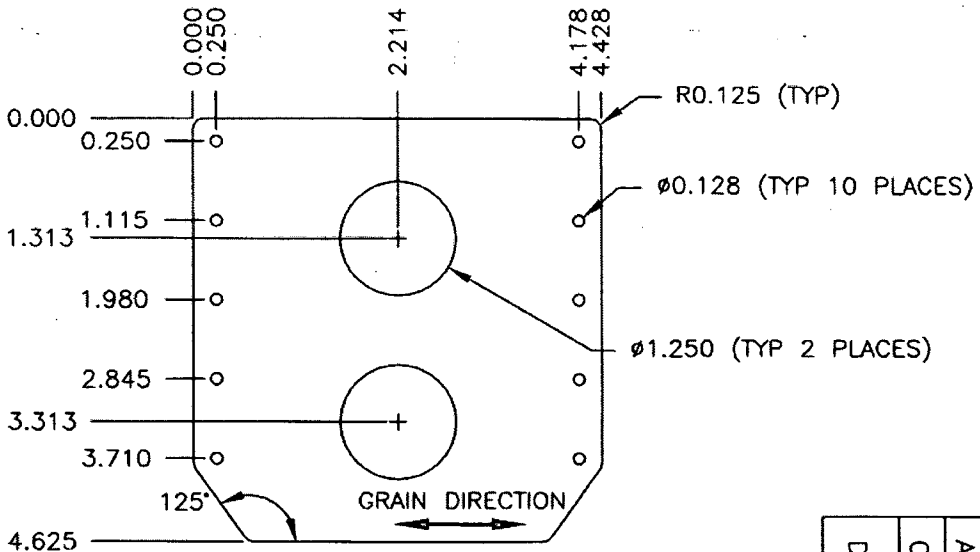
NOTE: Date & initial all entries





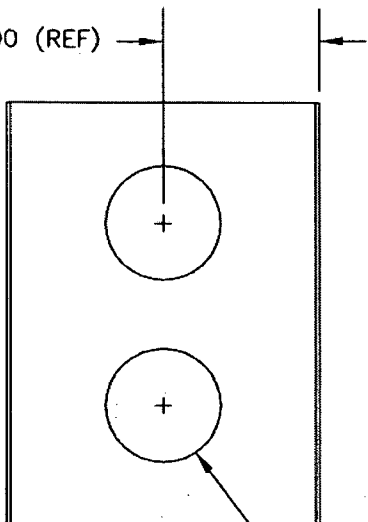
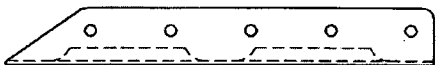


DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
BW	JP	DRAWING NO.	D2279	REV. D
CHECKED KE	APPROVED JP	TITLE	STEP SPACER	SHEET 1 OF 1
DATE 98.10.05		SCALE	1:2	
A	94.10.13	NEW ISSUE		
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881		
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912		



FLAT LAYOUT

FLANGE AFTER BENDING  
TOWARDS INSIDE OF PART  
USING DT8174 (2 PLACES)



R0.125

0.62

4.00

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 31407D

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
98.10.08 DS

UNDER REVIEW

size 15 q  
DESIGN OK, BUT CHECK WITH  
TS BEFORE MANUFACTURE

OK 4/4/09

